

5/30


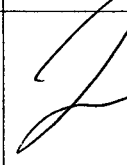

DART AEROSPACE LTD	Work Order:	23713
Description: Wearplate	Part Number:	D3319-1
Dwg: D3319 Rev. A page 1	Qty:	10
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	HJ	05.06.30	10
2	PG	Issue P/O: <u>7608305</u> Email or Ship DXF file to vendor Laser Cut flat pattern per Dwg D3319 Possible Supplier: Industrial Laser Material release note is required	U	0506-30	10
3	RG	Receive and inspect for transit damage Ensure material release note is attached	DL	05/07/28	10
4	QC6	Inspect dimensions as per inspection template D3319-1T1			
5	GA	Deburr if necessary			
6	GB	Form using DT8326 & DT8261 as per Dwg D3319 Dwg Rev: <u>5/20</u>			
7	GB	Form flat on press using DT8776 block Dwg Rev: _____			
8	QC6	Inspect dimensions as per Dwg D3319			
9	WS	Weld hard surface using D3319-1T2 as per QSI 004 and Dwg D3319 Dwg Rev: _____ <u>Qty</u> <u>Part Number</u> <u>Description</u> <u>Batch</u> A/R N/A 7560 Hardcoat Rod			
10	QC9	Inspect weld			
11	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3			
12	QC3	Inspect Powder Coat			
13	ST	Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3319-1, B/N: BXXXXX For Product Eligibility see PDA04-18 and Stock			
14	AC	Cost / part: <u>71.50</u>	Sue	05-10-20	
15	DC	Close W/O Inspect Level 21			

Rev	Date	Change	Revised By	Approved
A	05.05.12	New issue	KJ/JLM	<i>[Signature]</i>

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-10-19	4	Parts are no longer good. due too design change, not		Scrap; destroy. No use for engineering	 05-10-19	 05-10-19		 05-10-19

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

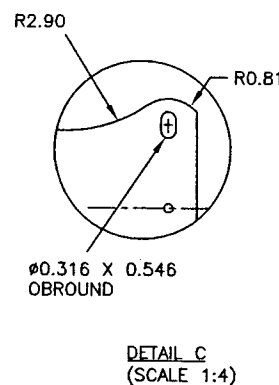
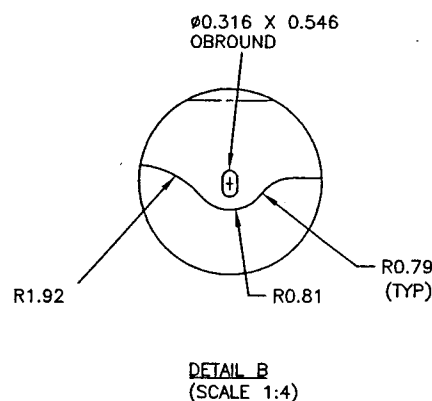
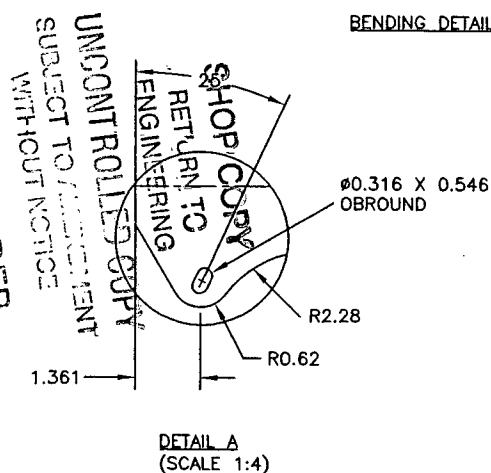
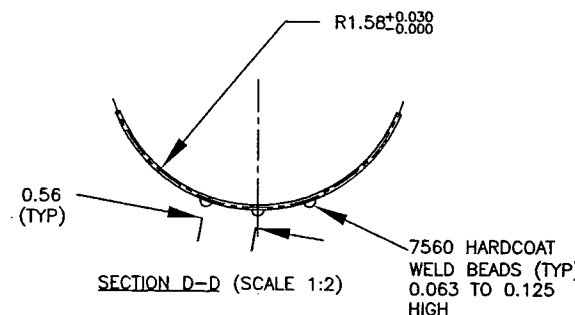
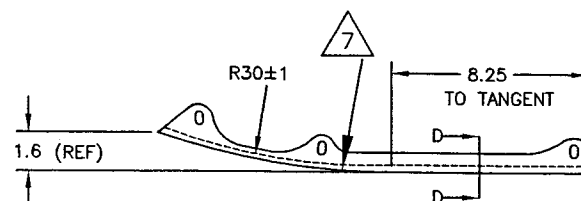
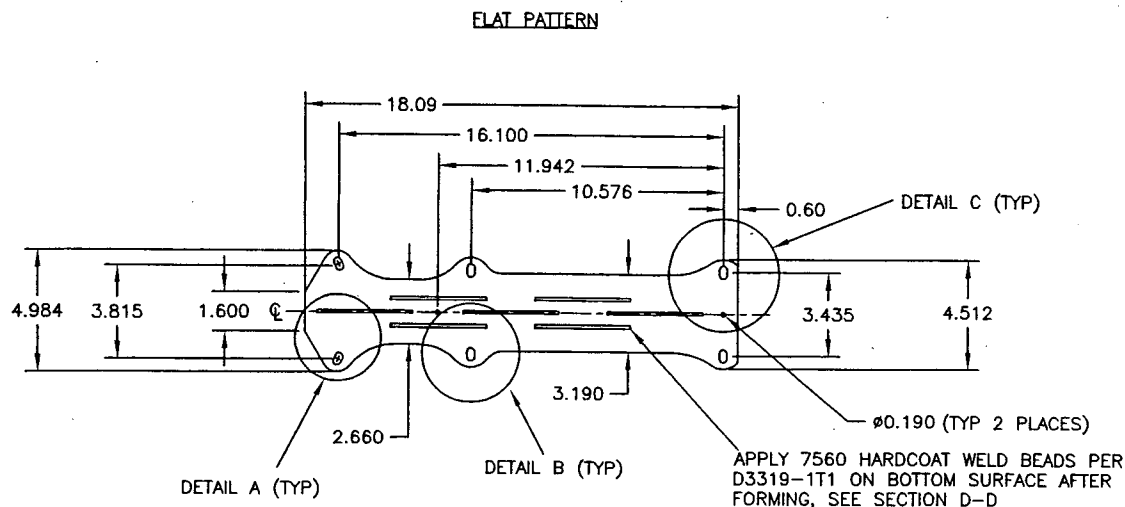
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

RELEASED
05-04-29

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD
CHECKED	PH	APPROVED	PH	HAWKESBURY, ONTARIO, CANADA
DATE	04.09.24	DRAWING NO.	D3319	REV. A
		TITLE	WEARPLATE	SHEET 1 OF 5
			NEW ISSUE	SCALE 1:8



D3319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-XX"

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jun 30, 2005
02:06 pm

Work Order No : 0023713
Project Name : D3319-1
Project For : WK530
Work Order Type : Main
Main WO Number :
House Part Number : D3319-1
Description : Wearplate
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 06-30-05
Est Finish Date : 07-30-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 92121, Auckland, New Zealand
Telephones: (09) 375 8998 / 375 8111 Auckland
(09) 235 8089 / 235 3535 Waikuku
Fax: (09) 375 8959

TEST CERTIFICATE

Ref: 5005/21329

CUSTOMER	Wilkinson	P41007DI002	SPECIFICATION	ASTMA1008 CS Type A	CERTIFICATE No	TC107796																						
CUSTOMER ON	90-21N-288		PRODUCT	CRA WIDE COIL	PAGE	1 of 1																						
MILL ON	453665		DIMENSIONS	0.033" x 48" x Coil	DATE	31 March 2005																						
PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT										MECHANICAL TESTS (TEST SPECIFICATION - ASTMA370)																
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE ()	BEND 180°	YIELD	T.S.	%ELONG G.L.=	HARDNESS HRB	r ()	LENGTH (feet)				
		x100										x1000						x10000		x100								
R9-455932-00	640077	5	TR	20	10	16	14	17	18	1	6	1	1					Good				41		2621				
R9-455933-00	640077	5	TR	20	10	16	14	17	18	1	6	1	1					Good				41		2723				
R9-455934-00	640077	5	TR	20	10	16	14	17	18	1	6	1	1					Good				50		2546				
R9-455935-00	640077	5	TR	20	10	16	14	17	18	1	6	1	1					Good				50		2789				

YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (G.L.) (A)=200mm (C)=80mm (E)=2" (B)=50mm (D)=5.65 ± So (F)=8"	PLASTIC STRAIN RATIO (r) (A)=r0 (C)=r45 (B)=r90 (D)=(r0+r90+2r45)/4	IMPACT TEST (A)=10mm x 10mm (B)=7.5mm x 10mm (C)=5mm x 5mm (D)=2.5mm x 10mm (E)=5mm x 10mm	CARBON EQUIVALENT VALUE (CE) (A)=C+Mn/6 (B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15 (C)=C+Mn/8+Si/24 (D)=
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WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Satish Misra*
QC METALLURGIST

20 GA CRMS